

Work Order ID 142437-2

142437

Page 1

Wednesday, March 09, 2016 12:33:53 PM

Item ID: D5235-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: LH Step Assembly

Start Date: 3/28/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/1/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: MAR 09 2016

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5235

A

110

0.05

110

Small Fab

Small Fab

Memo

0.00

1- ASSEMBLE FIXTURE DT10150 WITH BLOC "A", "B" AND "C" TO MANUFACTURE D5235-041.

2- ASSEMBLE D5273-041 FITTINGS TO D5274-1 STEP WITH PROSEAL AS PER DWG
A/R PROSEAL: 136953

3- INSERT ALL PARTS TOGETHER IN FIXTURE DT10150 AND TRANSFER DRILL HOLES USING DT10186 FOR D5271-3/-4 AND DT 10185 FOR D5271-1 AS PER DWG AND NOTES 9,10.

4- DISASSEMBLE AND DEBURR.

5- a) USE DT10170 DRILL JIG TO DRILL NUT PLATE HOLES IN D5272-1/-3 TUBE AS PER DWG.
b) DEBURR
c) TOUCH UP HOLES WITH ALODINE ONLY
d) INSTALL NUTPLATES IN TUBES

6- TOUCH UP HOLES WITH ALODINE ONLY ON D5271-1/-3 AND D5273-041 FITTINGS.

7- USE DT10150 TO RE-ASSEMBLE REST OF THE PARTS TOGETHER USING PROSEAL AS PER DWG
A/R PROSEAL: 136953

2X 17/06/13 DAS 08 9-88

Work Order ID 142437

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142437

Page 2

Item ID: D5235-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: LH Step Assembly
 Start Date: 3/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/1/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	CURE TIME 24h: _____								
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			DAS 36 JUN 14 2017
130 *130* SprayPaint Spray Painting	Memo PRIME AS PER DWG AND QSI005 4.2.1.3.3 (LET CURE BEFORE PAINTING AS PER QSI005) PRC DESOTO PRIMER: <u>136772</u> PAINT AS PER DWG AND QSI005 4.2.2.3 WHITE IMIRON PAINT: <u>137327</u>	0.07 0.00				1			DAS 41 9-89 JUN 15 2017

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[illegible]

Work Order ID 142437

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142437

Page 4

Item ID: D5235-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: LH Step Assembly

Start Date: 3/28/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/1/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

DAS
27
0-89
JUN 21 2017

17/6/21

JUN 21 2017

Wednesday, March 09, 2016 12:33:57 PM

142437

D5235-041

Required Date: 4/1/2016

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 15.07.28 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5271-1		Manufactured	No				Each	0.0000		42			
D5271-1									**	140320			
Forward Fitting													
D5271-3		Manufactured	No				Each	0.0000		42			
D5271-3									**				
LH Aft Fitting													
D5272-3		Manufactured	No				Each	19.0000		42			
D5272-3									**				
Aft Tube													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				18					
				140815				18		2			
				prelim				1					
				134702				1					
D5272-1		Manufactured	No				Each	19.0000		42			
D5272-1									**				
Fwd Tube													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				18					
				140318				18		2			
				prelim				1					
				134701				1					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	

Picklist Print

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Work Order ID: 142437

142437

Parent Item: D5235-041

D5235-041

Parent Item Name: LH Step Assembly

Start Date: 3/28/2016

Required Date: 4/1/2016

Start Qty: 4.00

Required Qty: 4.00

D5273-041

Manufactured No

Each 1.0000

D5273-041

End Fitting Assembly

**

84
140324

DAS
8
9-89

Location

Loc Qty

Loc Code

prelim

135150

1

Each

0.0000

D5274-1

Manufactured No

D5274-1

Step Extrusion

D5291-041

Manufactured No

D5291-041

Radius Block Assembly

Each

179.0000

**

5628

APR 07 2016

DAS
36
9-89

Location

Loc Qty

Loc Code

prelim

135144

4

4

ST162

175

175

140319

Each

1,022.000

**

28
T12 56

APR 07 2016

DAS
8
9-89

MS20426AD4-6

Purchased

No

MS20426AD4-6

Rivet

Location

Loc Qty

Loc Code

GA

1014

M128812

16

M133234

998

ST311

8

M132536

8

DAS
8
9-89

APR 07 2016

DAS
36
9-89

CR3212-4-5

134574

56x

DAS
36
9-89

17/06/13

Wednesday, March 09, 2016 12:33:57 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, March 09, 2016 12:33:57 PM

Page 3

Work Order ID: 142437

142437

Parent Item: D5235-041

D5235-041

Parent Item Name: LH Step Assembly

Start Date: 3/28/2016

Required Date: 4/1/2016

Start Qty: 4.00

Required Qty: 4.00

MS24694-S50

Purchased

No

Each

724.0000

MS24694-S50

Screw

4824
134502
DAS
6
9-89

Location

Loc Qty

Loc Code

over006

400

m134370

400

ST284

324

m133031

24

m133990

300

MS24694-S98

Purchased

No

Each

274.0000

MS24694-S98

Screw

5628
DAS
6
9-89

Location

Loc Qty

Loc Code

over006

200

m133990

100

m134134

100

ST283

74

m133483

74

10
18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

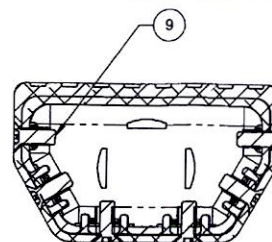


QA Closed: _____ Date: _____

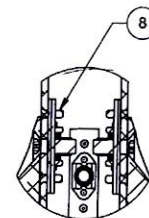
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐																																																																

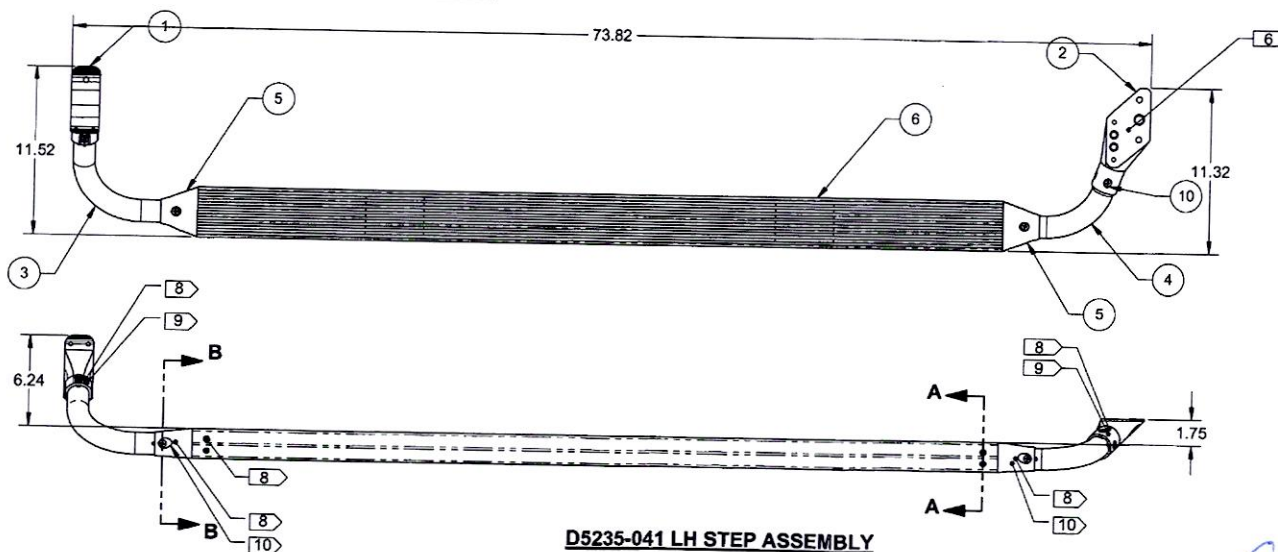
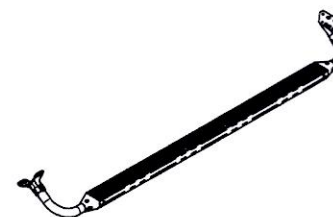
ITEM	QTY. -041	P/N	DESCRIPTION
	X	D5235-041	LH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-3	LH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	2	D5273-041	END FITTING ASSEMBLY
6	1	D5274-1	STEP EXTRUSION
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	MS20426AD4-6	RIVET
9	12	MS24694-S50	SCREW
10	14	MS24694-S98	SCREW



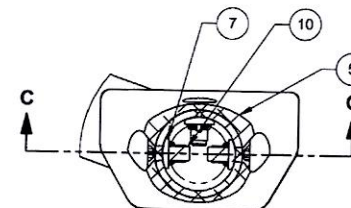
SECTION A-A



SECTION C-C



D5235-041 LH STEP ASSEMBLY



SECTION B-B

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-041" PER QSI 044 6.1
- 7) WEIGHT: 10.49 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/-3 TO D5272-1/-3
- 10) TRANSFER DRILL FROM D5273-041 TO D5272-1/-3

RELEASED
2015-12-07
EN 15-649

APPROVED

A	ISSUE	DESCRIPTION	CC	15.06.09
REV.			BY	DATE
DESIGN	CC			
DRAWN	CC			
CHECKED	VS			
MFG. APPR.	JLM			
APPROVED	HS			
DE APPR.	DS			
DATE	15.06.09			

DART AEROSPACE USA, INC
EUGENE, OREGON, USA

DRAWING NO.
D5235

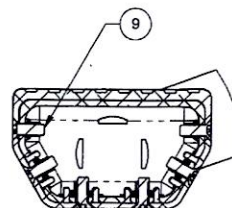
REV. A
SHEET 1 OF 4

TITLE
AW139 CABIN STEP

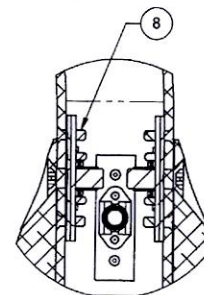
SCALE
NTS

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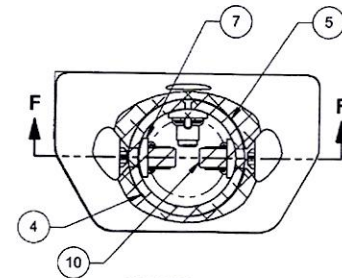
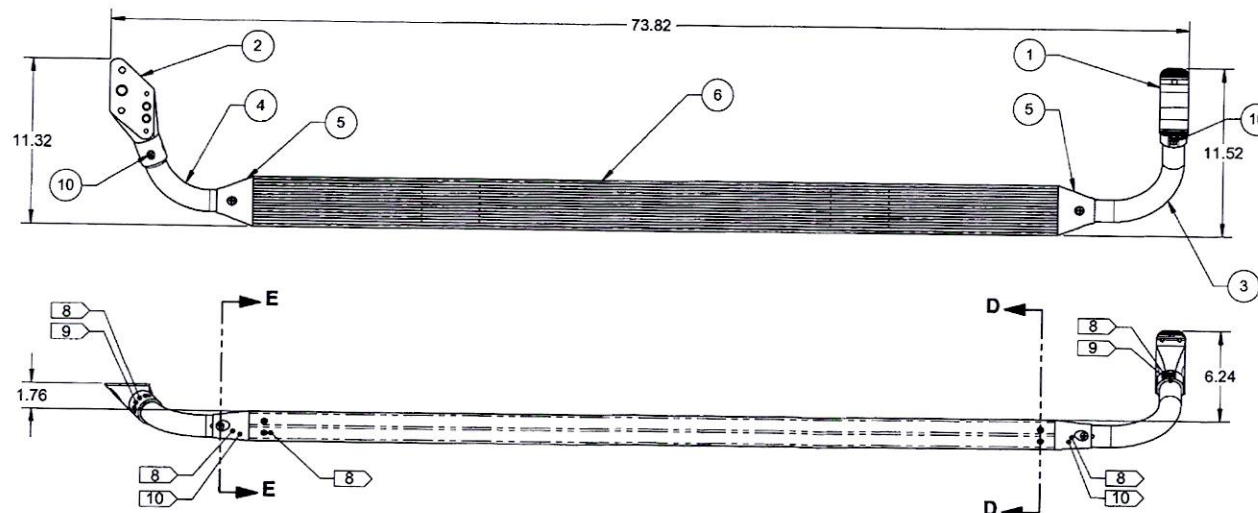
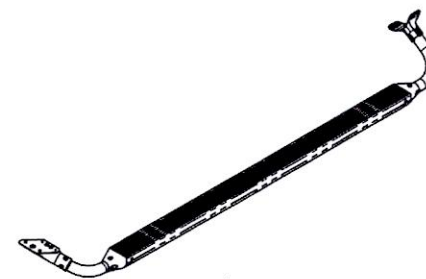
ITEM	QTY. -042	P/N	DESCRIPTION
	X	D5235-042	RH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-4	RH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	2	D5273-041	END FITTING ASSEMBLY
6	1	D5274-1	STEP EXTRUSION
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	MS20426AD4-6	RIVET
9	12	MS24694-S50	SCREW
10	14	MS24694-S98	SCREW



SECTION D-D



SECTION F-F



SECTION E-E

D5235-042 RH STEP ASSEMBLY

NOTES:

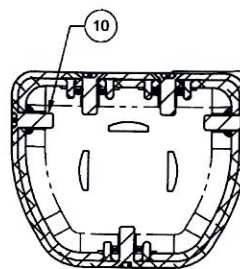
- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE. APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-042" PER QSI 044 6.1
- 7) WEIGHT: 10.49 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/4 TO D5272-1/3
- 10) TRANSFER DRILL FROM D5273-041 TO D5272-1/3

RELEASED
2015-12-07

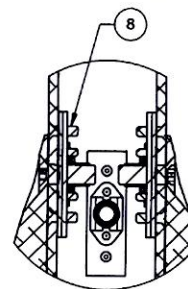
APPROVED

DESIGN	CC	DART AEROSPACE USA, INC	
DRAWN	CC	EUGENE, OREGON, USA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5235	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	AW139 CABIN STEP	NTS
DATE	15.06.09	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC	
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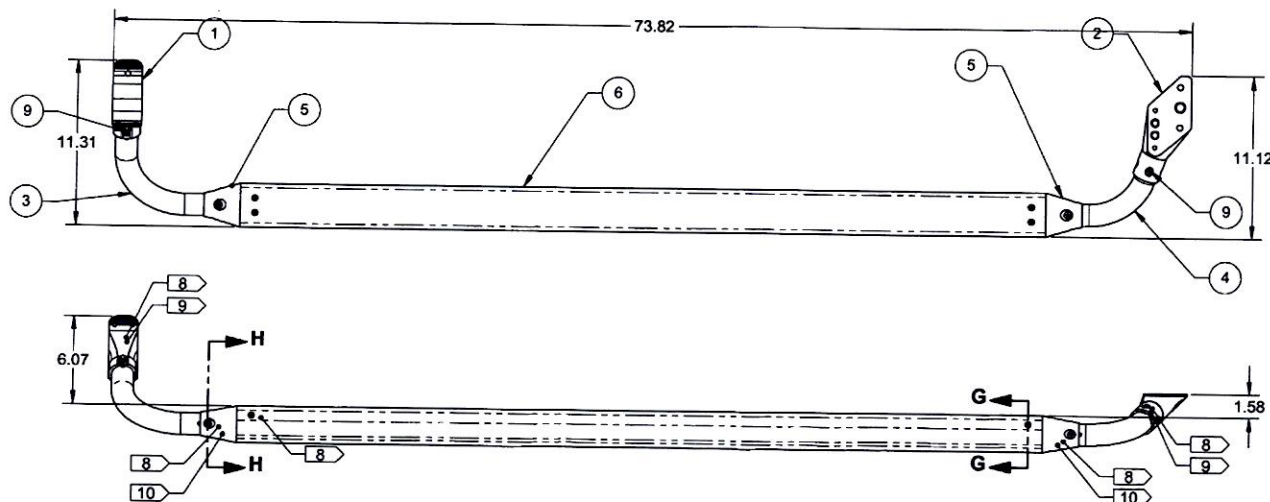
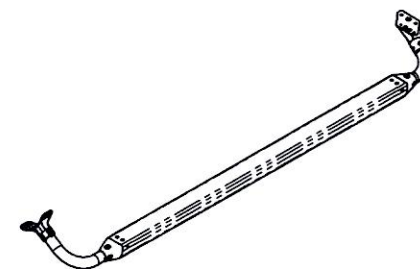
ITEM	QTY. -043	P/N	DESCRIPTION
	X	D5235-043	LH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-3	LH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	2	D5273-043	END FITTING
6	1	D5274-3	STEP EXTRUSION
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	MS20426AD4-6	RIVET
9	14	MS24694-S98	SCREW
10	10	MS24694-S50	SCREW



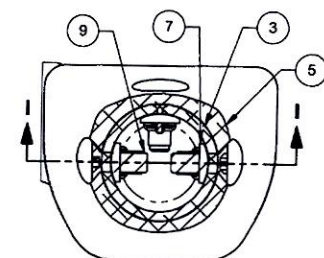
SECTION G-G



SECTION I-I



D5235-043 LH STEP ASSEMBLY



SECTION H-H

NOTES:

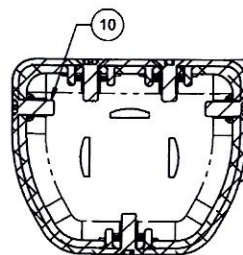
- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-043" PER QSI 044 6.1
- 7) WEIGHT: 8.66 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/-3 TO D5272-1/-3
- 10) TRANSFER DRILL FROM D5273-043 TO D5272-1/-3

RELEASED
2015-12-07

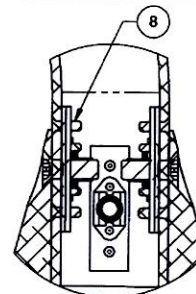
APPROVED

DESIGN	CC	DART AEROSPACE USA, INC EUGENE, OREGON, USA	
DRAWN	CC		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5235	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	AW139 CABIN STEP	NTS
DATE	15.06.09	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

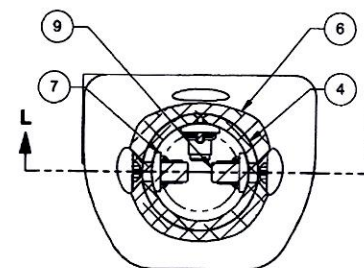
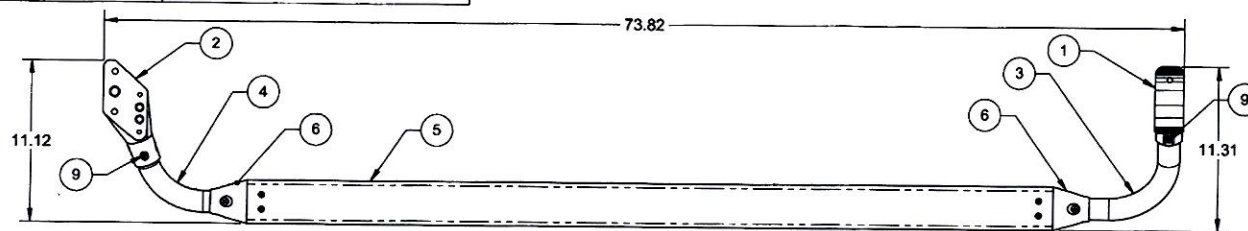
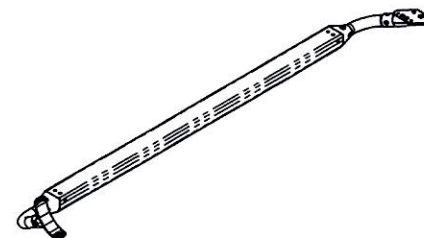
ITEM	QTY. .044	P/N	DESCRIPTION
	X	D5235-044	RH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-4	RH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	1	D5274-3	STEP EXTRUSION
6	2	D5273-043	END FITTING
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	MS20426AD4-6	RIVET
9	14	MS24694-S98	SCREW
10	10	MS24694-S50	SCREW



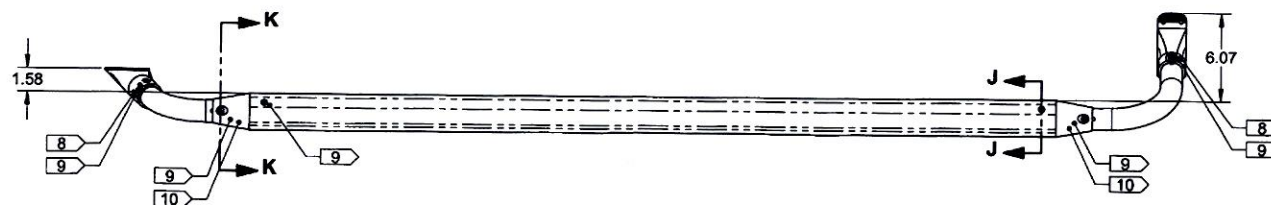
SECTION J-J



SECTION L-L



SECTION K-K



D5235-044 RH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-044" PER QSI 044 6.1
- 7) WEIGHT: 8.66 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/4 TO D5272-1/3
- 10) TRANSFER DRILL FROM D5273-043 TO D5272-1/3

RELEASED
2015-12-07

APPROVED

DESIGN	CC	DART AEROSPACE USA, INC	
DRAWN	CC	EUGENE, OREGON, USA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5235	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	AW139 CABIN STEP	NTS
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